


- NOTE:
- 1. THIS IS A ULTRA-HIGH VACUUM COMPONENT (UHV).
  - 2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
    - A) CIMCOOL 5 STAR 49
    - B) TRIM SOL
  - 3. ELECTROPOLISH, TO 63 MICROINCH RMS. CLEAN PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN BEFORE ELECTROPOLISHING.
  - 3. ALL DIMENSIONS IN [ ] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.

02	UPDATED	RK		
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM		DWG. & ELECTRONIC FILE No.		NOMENCLATURE OR DESCRIPTION				MATERIAL / SPEC		QTY	
PARTS LIST											
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES				ELECTRONIC FILE NUMBER		THIS DRAWING IS THE PROPERTY OF					
TOLERANCES				A18306				ARGONNE NATIONAL LABORATORY			
DECIMALS		ANGULAR									
X. - .015		- .25									
.XX - .010											
.XXX - .005											
SURFACE ROUGHNESS				125							
REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX.											
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1											
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5											
DRAWN BY		DATE		CHIEF DESIGN ENGINEER		DATE		TITLE			
RICK KRAKORA		12/92		D. SHU		8/9/93		ADVANCED PHOTON SOURCE			
CHECKED BY		DATE		GP LEADER		DATE		S1 SAFETY SHUTTER			
T. SANCHEZ		7/26/93		T. M. KUZAY		8/9/93		RAIL ASSEMBLY			
DESIGNER		DATE		PROJECT MGR		DATE		STOP BAR			
RICK KRAKORA		12/92									
RESPONSIBLE ENGINEER		DATE		APPROVED/RELEASED		DATE					
T. SANCHEZ		7/26/93									
MATERIAL				SCALE		1=1		SIZE		DRAWING NUMBER	
.63 THK x SEE DWG				SHEET		1 of 1		C		P4102010108-210101-02	
SST 304											
DO NOT SCALE DRAWING											